

PROCESS CARTRIDGE REMANUFACTURING METHOD

FIELD OF THE INVENTION AND RELATED ART

The present invention relates to a
5 remanufacturing method for a process cartridge.

Here, the process cartridge is a cartridge
containing at least a developing roller as developing
means and an electrophotographic photosensitive member
as a unit, the cartridge being detachably mountable to
10 a main assembly of an electrophotographic image
forming apparatus.

The electrophotographic image forming
apparatus is an apparatus in which an image is formed
on a recording material (recording paper, textile or
15 the like) using an electrophotographic image forming
process, and includes an electrophotographic copying
machine, an electrophotographic printer (a LED
printer, laser beam printer and so on, an
electrophotographic printer type facsimile machine, an
20 electrophotographic word processor and the like.

In an electrophotographic image forming
apparatus using an electrophotographic image forming
process, a process cartridge is used which integrally
contains an electrophotographic photosensitive member
25 and process means actable on the electrophotographic
photosensitive member, the process cartridge being
detachably mountable to the main assembly of the

electrophotographic image forming apparatus. With
this process cartridge type, the maintenance of the
apparatus can be carried out in effect without service
people. Therefore, the process cartridge type is
5 widely used in the field of the electrophotographic
image forming apparatus.

Such a process cartridge forms an image on
recording material with toner. Therefore, the toner
is consumed in accordance with image forming
10 operations. When the toner is consumed up to such an
extent that user is not satisfied with the image
quality, the commercial value of the process cartridge
is lost.

It is desired that such a used process
15 cartridge are is given the commercial value, again by
remanufacturing the process cartridge through easy
method.

SUMMARY OF THE INVENTION

20 Accordingly, it is a principal object of the
present invention to provide a remanufacturing method
of a process cartridge.

It is another object of the present invention
to provide a remanufacturing method of a process
25 cartridge in which when the process cartridge is
transported, the toner is prevented from leaking out.

It is a further object of the present

invention to provide a remanufacturing method of a process cartridge wherein the process cartridge with which the toner is consumed to such an extent that user is not satisfied with the image quality is recycled to be given the commercial value.

According to an aspect of the present invention, there is provided a remanufacturing method of remanufacturing a process cartridge comprising:

- (a) a step of preparing a used process cartridge which comprises a toner developing container, a cleaning container and pins for coupling said toner developing container and said cleaning container at opposite longitudinal ends of said process cartridge;
 - said toner developing container including a toner accommodating portion, a toner supply opening, a developing roller and a developing blade;
 - said cleaning container including an electrophotographic photosensitive drum;
- (b) a container separating step of separating said process cartridge into said toner developing container and said developing container by disengaging said pins from said process cartridge;
- (c) a developing roller dismounting step of dismounting said developing roller from said toner developing container separated by said container separating step;

(d) a developing blade dismounting step of dismounting said developing blade from said toner developing container separated by said container separating step;

5 (e) an elastic member mounting step of mounting an elastic member to a longitudinally inside of an end seal provided adjacent each of opposite longitudinal ends of a or said developing roller, at a position laterally outside of said end seal;

10 (f) a developing blade mounting step of mounting a or said developing blade on a or said toner developer container;

(g) a developing roller mounting step of mounting a or said developing roller on said toner developer container having said developing blade;

15 (h) a toner refilling step of refilling the toner into a or said toner accommodating portion of said toner developing container having said developing blade and said developing roller; and

20 (i) a container coupling step of coupling said toner developing container having said developing blade and said developing roller with a or said cleaning container by engaging a or said pin into them.

25 According to another aspect of the present invention, there is provided a remanufacturing method of remanufacturing a process cartridge comprising:

(a) a step of preparing a used process cartridge which comprises a toner developing container, a cleaning container and pins for coupling said toner developing container and said cleaning container at opposite longitudinal ends of said process cartridge;

said toner developing container including a toner accommodating portion, a toner supply opening, a developing roller and a developing blade;

10 said cleaning container including an electrophotographic photosensitive drum;

(b) a container separating step of separating said process cartridge into said toner developing container and said developing container by disengaging said pins from said process cartridge;

(c) a developing roller dismounting step of dismounting said developing roller from said toner developing container separated by said container separating step;

20 (d) a developing blade dismounting step of dismounting said developing blade from said toner developing container separated by said container separating step;

(e) an elastic member mounting step of mounting an elastic member to a longitudinally inside of an end seal provided adjacent each of opposite longitudinal ends of a or said developing roller, at a

position laterally outside of said end seal;

(f) a flexible sheet mounting step of mounting a flexible sheet to a or said toner developing container so as to extend along the longitudinal direction of said developing roller when said developing roller is mounted to said toner developing container;

(g) first and second side seal mounting step of mounting a first side seal continuously on a longitudinal end of said flexible sheet mounted on said toner developing container having the flexible sheet and said toner developing container having the flexible sheet, and a second side seal continuously on the other longitudinal end of said flexible sheet and said toner developing container having flexible sheet;

(h) a developing blade mounting step of mounting a or said developing blade on said toner developer container having the flexible sheet;

(i) a developing roller mounting step of mounting a or said developing roller on said toner developer container having the flexible sheet;

(j) a toner refilling step of refilling the toner into a or said toner accommodating portion of said toner developing container having said flexible sheet; and

(k) a container coupling step of coupling

said toner developing container having said flexible sheet with a or said cleaning container by engaging a or said pin into them.

According to a further aspect of the present invention, there is provided a remanufacturing method of remanufacturing a process cartridge comprising:

(a) a step of preparing a used process cartridge which comprises a toner developing container, a cleaning container and pins for coupling said toner developing container and said cleaning container at opposite longitudinal ends of said process cartridge;

said toner developing container including a toner accommodating portion, a toner supply opening, a developing roller and a developing blade;

said cleaning container including an electrophotographic photosensitive drum;

(b) a container separating step of separating said process cartridge into said toner developing container and said developing container by disengaging said pins from said process cartridge;

(c) a developing roller dismounting step of dismounting said developing roller from said toner developing container separated by said container separating step;

(d) a developing blade dismounting step of dismounting said developing blade from said toner

developing container separated by said container separating step;

(e) an elastic member mounting step of mounting an elastic member to a longitudinally inside
5 of an end seal provided adjacent each of opposite longitudinal ends of a or said developing roller, at a position laterally outside of said end seal;

(f) a developing blade mounting step of mounting a or said developing blade on a or said toner
10 developer container;

(g) a developing roller mounting step of mounting a or said developing roller on said toner developer container having said developing blade;

(h) a toner refilling step of refilling the
15 toner into a or said toner accommodating portion of said toner developing container having said developing blade and said developing roller, through the toner supply opening of said toner developing container having said seal; and

(i) a container coupling step of coupling
20 said toner developing container having said developing blade and said developing roller with a or said cleaning container by engaging a or said pin into them.

25 According to a further aspect of the present invention, there is provided a remanufacturing method of remanufacturing a process cartridge comprising:

(a) a step of preparing a used process cartridge which comprises a toner developing container, a cleaning container and pins for coupling said toner developing container and said cleaning container at opposite longitudinal ends of said process cartridge;

said toner developing container including a toner accommodating portion, a toner supply opening, a developing roller and a developing blade;

10 said cleaning container including an electrophotographic photosensitive drum;

(b) a container separating step of separating said process cartridge into said toner developing container and said developing container by disengaging said pins from said process cartridge;

(c) a developing roller dismounting step of dismounting said developing roller from said toner developing container separated by said container separating step;

20 (d) a developing blade dismounting step of dismounting said developing blade from said toner developing container separated by said container separating step;

(e) an elastic member mounting step of mounting an elastic member to a longitudinally inside of an end seal provided adjacent each of opposite longitudinal ends of a or said developing roller, at a

position laterally outside of said end seal;

(f) a flexible sheet mounting step of mounting a flexible sheet to a or said toner developing container so as to extend along the longitudinal direction of said developing roller when said developing roller is mounted to said toner developing container;

(g) first and second side seal mounting step of mounting a first side seal continuously on a longitudinal end of said flexible sheet mounted on said toner developing container having said flexible sheet and said toner developing container having said flexible sheet, and a second side seal continuously on the other longitudinal end of said flexible sheet and said toner developing container having said flexible sheet;

(h) a developing blade mounting step of mounting a or said developing blade on said toner developer container having the flexible sheet;

(i) a developing roller mounting step of mounting a or said developing roller on said toner developer container having said flexible sheet;

(j) a toner refilling step of refilling the toner into a or said toner accommodating portion of said toner developing container having said flexible sheet, said developing blade and said developing roller, through the toner supply opening of said

toner developing container having said flexible sheet;
and

(k) a container coupling step of coupling
said toner developing container having said flexible
5 sheet, said developing blade and said developing
roller with a or said cleaning container by engaging a
or said pin into them.

These and other objects, features and
advantages of the present invention will become more
10 apparent upon a consideration of the following
description of the preferred embodiments of the
present invention taken in conjunction with the
accompanying drawings.

15 BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 is a longitudinal sectional view of
an electrophotographic image forming apparatus.

Figure 2 is a longitudinal sectional view of
an electrophotographic image forming apparatus.

20 Figure 3 is a perspective view of an
electrophotographic image forming apparatus.

Figure 4 is a longitudinal sectional view of
a process cartridge.

Figure 5 is a perspective view of a process
25 cartridge.

Figure 6 is a side view of a process
cartridge.

Figure 7 is a partly broken side view of a process cartridge.

Figure 8 is a top plan view of a frame of a toner developing container.

5 Figure 9 is a side view of a drum shutter.

Figure 10 is a top plan view of a process cartridge.

Figure 11 is an exploded perspective view of a toner developing container and a cleaner container.

10 Figure 12 is a developed schematic view of a cleaner container.

Figure 13 is a horizontal sectional view of a toner developing container.

15 Figure 14 is a perspective view of a toner developing container without a developing roller.

Figure 15 is an exploded perspective view of supporting means for the developing roller.

Figure 16 is an exploded perspective view of a toner developing container.

20 Figure 17 is a top plan view of a toner developing container from which the developing roller and the developing blade have been removed.

Figure 18 is an enlarged review of E part in Figures 17.

25 Figure 19 is an enlarged view of F part of Figures 17

Figure 20 is a front view of a toner

developing container as seen in the direction opposite from the mounting direction of the process cartridge.

Figure 21 is a longitudinal sectional view of a process cartridge.

5 Figure 22 is a side view of a process cartridge.

Figure 23 is a side view of a process cartridge.

10 Figure 24 is a side view of a toner developing container.

Figure 25 is a side view of a toner developing container.

15 Figure 26 is a longitudinal sectional view of a connecting portion between the toner developing container and the cleaner container.

Figure 27 is a perspective view of a toner developing container and a cleaner container.

Figure 28 is a top plan view of a toner developing container.

20 Figure 29 is a perspective view of a cleaning blade.

Figure 30 is a front view illustrating a sealing step for a cutaway portion.

25 Figure 31 is a top plan view of the device shown in Figure 30.

Figure 32 is a side view of the device shown in Figure 30.

Figure 33 is a front view of a side pad.

Figure 34 is a side view after the side cover seal is mounted.

Figure 35 is a top plan view of an end lateral seal.

Figure 36 is a front view showing a disposition of the end lateral seal.

Figure 37 is a front view showing mounting of a Figure 37 groove filling seal.

Figure 38 is a side view of the Figure 38 groove filling seal.

Figure 39 is a perspective view of the Figure 39 groove filling seal.

Figure 40 is a top plan view illustrating mounting of the Figure 40 Figure 40 groove filling seal.

Figure 41 is a side view of the device shown in Figure 40.

Figure 42 is a side view illustrating a positional relationship between the Figure 42 groove filling seal and the seal seal.

Figure 43 is a top plan view illustrating a position our relationship between the Figure 43 groove filling seal and the jaw seal.

Figure 44 is a front view of a developing roller at a longitudinal and of the toner developing container as seen from the lower side.

Figure 45 is a longitudinal sectional view of an end seal portion.

Figure 46 is a top plan view of a toner developing container.

5 Figure 47 is a longitudinal sectional view of a support structure for the photosensitive drum.

Figure 48 is a side view of a support structure for the charging roller.

10 Figure 49 is a longitudinal sectional view of a cleaning device for a cleaner container.

Figure 50 is a perspective view of a nozzle of the cleaning device.

Figure 51 is a flow chart of the cleaning function.

15 Figure 52 is a perspective view of the photosensitive drum and the developing roller during image forming operation.

20 Figure 53 is a longitudinal sectional view of the process cartridge during the transportation thereof.

Figure 54 is a perspective view illustrating a relationship between the photosensitive drum and the charging roller during transportation of the process cartridge.

25 Figure 55 is a perspective view of a process cartridge during transportation thereof.

Figure 56 is a longitudinal sectional view of

a toner filling according to a further embodiment of the present invention.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

5 The preferred embodiments of the present invention will be described in conjunction with the accompanying drawing us.

10 The description will be made first as to a general arrangements of an image forming apparatus and in process cartridge according to an embodiment of the present invention and then as the manufacturing method of the process cartridge. The description will be made then as to the steps of disassembling and re-assembling of the process cartridge and as to the reassembled a process cartridge.

15 The remanufacturing of the process cartridge from which the toner has been used up is disassembled into the toner developing container and the cleaner container, and the toner developing container is partly disassembled, and they are reassembled to provide a process cartridge having the toner developing container which is similar in function to the new process cartridge but has a partly different structure from the new process cartridge.

20 Referring to Figures 1 to 5, the description will be made as to the process cartridge and an image forming apparatus to which the process cartridge is

detachably mountable. The description will be made as to the general arrangements of the process cartridge and in the image forming apparatus, and then as to the structure of the cartridge frames and father as to the coupling of the frames.

(General Arrangement)

The image forming apparatus in this embodiment is an electrophotographic image forming apparatus (laser beam printer) A, as shown in Figure 1, wherein an electrophotographic photosensitive member in the form of a drum is exposed to information light modulated in accordance with image information from an optical system 1, so that latent image is formed on the photosensitive member, and the latent image is developed into a toner image. In synchronism with the formation of the toner image, the recording material 2 is fed out one by one from a sheet feeding cassette 3a using a pick-up roller 3b and separation claws 3c press-contacted at the corners of the top surface of the recording material 2, and the sheet is fed by feeding means 3 including a feeding path 3d and a pair of registration rollers. The toner image formed on the electrophotographic photosensitive member in the process cartridge B is transferred onto the recording material 2 by applying a voltage to transfer means in the form of a transfer roller 4, and then the recording material 2 is fed to fixing means 5

on a feeding path 3f. The fixing means 5 comprises a driving roller 5a and a fixing roller 5c containing a heater 5b therein, and a pressure and heat is imparted to the recording material 2 which is passing
5 therethrough, by which the transferred toner image is fixed on the recording material. The recording material 2 is further fed by discharging rollers, and is discharged to a discharging portion 6 through a reverse feeding path.

10 On the other hand, the process cartridge B contains the electrophotographic photosensitive member and at least one of process means. Here, the process means includes charging means for electrically
15 charging the electrophotographic photosensitive member, the developing means for developing a latent image formed on the electrophotographic photosensitive member, cleaning means for cleaning the surface of the electrophotographic photosensitive member to remove
20 residual toner. As shown in Figure 4, in the process cartridge B of this embodiment, the electrophotographic photosensitive member in the form of an electrophotographic photosensitive drum 7 having a photosensitive layer is rotated, and a voltage is
25 applied on the charging roller 8 which is the charging means, so that surface of the photosensitive drum 7 is uniformly charged, and the photosensitive drum 7 is exposed to light image from the optical system 1

through an opening 9, by which and electrostatic latent image is formed, and the image is developed by developing means 10.

5 In the developing means 10, the toner in a toner accommodating portion 10a is fed out by feeding means in the form of a rotatable toner feeding member 10b, and a developing roller 10d containing therein a stationary magnet is rotated, by which a layer of toner particles triboelectrically charged by the developing
10 blade 10e is formed on the surface of the developing roller 10d. The toner is selectively transferred onto the photosensitive drum 7 so that toner image is formed. The developing roller 10d functions to supply the toner to the photosensitive drum 7. The
15 developing blade 10e functions to regulate a thickness of the toner layer on the surface of the developing roller 10d.

The transfer roller 4 is supplied with a voltage having a polarity opposite from the polarity
20 of the toner image, by which the toner image is transferred onto the recording material 2.

Thereafter, the residual toner remaining on the photosensitive drum 7 is scraped off by the cleaning blade 11a, and the removed toner is received by a
25 receptor sheet 11b, and the received toner is collected into a removed toner accommodating portion 11c.

(Cartridge Mounting Means)

Various parts such as photosensitive drum 7 is supported and accommodated in a cartridge frame which is provided by coupling the toner developing container 12 and the cleaner container 13. The cartridge is mounted to the main assembly 14 of the apparatus.

In the cartridge mounting means, when the cover member 15 is opened by rotating it about the shaft 15a (Figures 1, 2), there is guide grooves 16 which is inclined the award toward the rear side at each of the left and right sides of the cartridge mounting space as shown in Figure 2. The guide grooves 16 are disposed substantially symmetrically. The guide groove 16 is substantially linear. At the inlet side of the guide groove 16 there is provided a positioning portion 16c (main assembly side positioning portion 16c).

On the other hand, at the of the opposite outer ends of the process cartridge, there are provided guide portions correspondingly to the guide grooves 16 to be guided by the guide groove 16. The guide portions are projected substantially symmetrically at the opposite longitudinal ends, respectively. As shown in Figure 5, it comprises a boss 18 and a rib 19 which are integral. The boss 18 and the rib 19 are integrally formed with the cleaner

container 13 to which the photosensitive drum 7 is mounted, and the boss 18 is disposed on an extension of a rotational excess of the photosensitive drum 7, and the rib 19 is extended from the boss 18 in an inserting direction of the process cartridge B as indicated by an arrow C in Figure 5. The rib 19 extends inclined downwardly in conformity with the guide groove 16.

With this structure, when the process cartridge is to be mounted to the main assembly, as shown in Figure 2, the cover member 15 is open, and the ribs 19 are engaged into the guide grooves 16, and then, the process cartridge B is inserted into the main assembly 14 of the apparatus. With the insertion, the process cartridge B makes a translational motion, that is, linear motion inclined downward. When the process cartridge B is further inserted, the boss 18 of the process cartridge B is seated on the main assembly side positioning portion 16c in the inlet of the guide groove 16. Simultaneously, the free end 19a of the rib 19 is abutted to a stopper surface 16a of the guide groove 16 by a moment about the boss 18 produced by the weight of the process cartridge B. The gravity center of the process cartridge B is at rib 19 side of the boss 18. Thus, the drum gear 51a (Figure 5) fixed to an end of the photosensitive drum 7 is brought into

meshing engagement with a driving gear 22 (Figure 2) provided in the main assembly 14, so that driving force can be transmitted to the process cartridge B.

Then, the cover member 15 is closed, by which
5 the shutter opening lever 55 which is interrelated with the cover member is rotated in the clockwise direction about the shaft 55c from a position 55a to a position 55b, so that it is engaged with a pin 28a provided on the drum shutter member 28 as shown in
10 Figure 10, and the drum shutter member 28 is opened about a pin 29 mounted to the cleaner container 13 against a spring force of a spring 27, thus opening a transfer opening 13n. The coil spring 27 is fitted around the pin 29, and one end thereof is engaged to
15 the cleaner container 13, and the other end is engaged to the drum shutter member 28, and therefore, when the cover member 15 is open or when the process cartridge B is outside the main assembly 14, the drum shutter member 28 closes the transfer opening 13n by the
20 spring force of the coil spring 27.

When the process cartridge B is to be taken out, the cover member 15 is opened, which the shutter opening lever 55 is rotated about the shaft 55c to return from the position 55b to the position 55a.
25 Then, drum shutter member 28 rotates about the pin 29 by the spring force of the coil spring 27, thus closing the transfer opening 13n. The process

cartridge B is pulled up such that in the boss 18 is away from the positioning portion 16c, and thereafter, the process cartridge B is further pulled up such that ribs 19 are guided by the guide grooves 16.

5 (Structure of Cartridge Frame)

The description will be made as to the structure of the cartridge frame. The cartridge frame is made of polystyrol resin material by injection molding, and as shown in Figure 4, a lower developing
10 frame 12b is welded to a side of the developing device frame 12a, and a cap member 12c is welded to the upper portion, thus constituting a toner developing container 12. A cap member 13b is welded to a top of a cleaning frame 13a to constitute an integral cleaner
15 container 13. Then, the cleaner container 13 is coupled with the toner developing container 12 to constitute a cartridge frame.

The developing device frame 12a is provided at an end thereof with a toner supply opening 12a1, as
20 shown in Figure 13, 14, is also provided at one longitudinal end with a toner filling opening 12a2. The developing device frame 12a is provided therein with a plurality of erected supporting members (not shown) in the longitudinal direction. The toner
25 supply opening 12a1 permits supply of the toner from the toner accommodating portion 10a to the developing roller 10d. The toner in the toner accommodating

portion 10d is supplied to the developing roller 10d through the toner supply opening 12a1.

When the developing means is mounted in place, as shown in Figures 4, 13, a toner feeding member 10b is mounted in the developing device frame 12a, and thereafter, the cap member 12c is welded to the developing device frame 12a. Subsequently, a toner seal 31 in the form of a film is welded on a surface 12a5 of the seat formed around the circumference of the toner supply opening 12a1 of the toner developing container 12 to seal the opening 12a1. Then, the toner is filled through the toner filling opening 12a2, and thereafter, the filling opening 12a2 is plugged by a cap 32 to seal the toner accommodating portion 10a. The toner seal 31 sealing the toner supply opening 12a1, as shown in Figure 13, is folded back at one longitudinal end of the opening 12a1, and the free end thereof is extended out through a slit 12a8 of the developing device frame 12a. The free end of the toner seal 31 is nipped by fingers of the user and is pulled out when the user starts use of the process cartridge B.

When it is pulled out, the sailing is not complete at the portion where the toner seal 31 extends through the toner developing container 12.

Therefore, as shown in Figure 13, an elastic sealing material 10h such a felt is provided in the

slit 12a8 at an end, closer to the fee end, of the toner seal 31.

As shown in Figure 13, the elastic sealing material 10h is overlaid on the toner seal 31 and
5 urges the toner seal 31. Therefore, when the toner seal 31 is pulled out, the elastic sealing material 10h occupies the slit 12a8 which has been occupied by the toner seal 31 to be press-contacted to a wall of the developing device frame 12a, thus preventing
10 leakage of the toner to the outside.

The description will be made as to the mounting of the elastic sealing material 10h. As shown in Figure 15, a part of the arcuate portion 12a6 of the developing device frame 12a is provided with an
15 angle groove 12a26 extending in the longitudinal direction. The bottom of the angle groove 12a26 is flush with the toner seal sticking seat surface 12a5. An elastic sealing material 10h such as a felt or the like is stuck on a piece 10j engaged in the angle
20 groove 12a26.

With this structure, even when the toner seal 31 is pulled out, the toner is prevented from leaking to the outside of the toner developing container 12 through the slit 12a8.

25 Then, the lower developing frame 12b is welded to the developing device frame 12a. As shown in Figure 8, the developing device frame 12a is

provided at the opposite longitudinal ends of the toner supply opening 12a1 with arcuate portions 12a6 at which the end seals 34 are to be mounted. A flat flange 12a16 is extended between the arcuate portions 12a6 below the seal sticking seat surface 12a5, and the flange 12a16 is substantially perpendicular to the seal sticking seat surface 12a5. On dead hand, lower developing frame 12b is engaged with you in the longitudinally opposing surfaces of the arcuate portions 12a6. Therefore, in concentration of manufacturing errors, the lower developing frame 12b has a length which is smaller than the distance between the opposing surfaces of the arcuate portion 12a6 by $2 \times g$ where g is a gap at each ends. The flange 12a16 is provided with holes 12a17, and the lower developing frame 12b is provided with dowels 12b3 for engagement with the holes 12a17, respectively. With the dowels 12b3 being in engagement with the respective hole 12a17, the bottom surface of the lower developing frame 12b and the top surface of the flange 12a16 of the developing device frame 12a are welded to each other. By doing so, gap g is formed between the arcuate portion 12a6 and the lower developing frame 12b at each end. The dimension of the gap g is not constant when the lower developing frame 12b is fixed to the developing device frame 12a.

When the lower developing frame 12b is

engaged with the developing device frame 12a, a
sealing material 39 such as a felt is inserted between
the developing device frame 12a and each of the
longitudinal opposite ends of the lower developing
5 frame 12b.

Each of the opposite ends of the lower
developing frame 12b is provided with an outward
projection 12b2 (Figure 8). The developing device
frame 12a is provided at each of the end portions with
10 a recess 12a18 for engagement with a projection 12b2
when the dowels 12b3 are engaged with the holes 12a17
for the purpose of welding or bombing of the lower
developing frame 12b. As shown in Figure 20, a gap g1
is provided between the recess 12a18 and the
15 projection 12b2. The gap is substantially equal to
the gap g formed between the lower developing frame
12b and the arcuate portion 12a6.

As shown in Figure 8, the arcuate portion
12a6 of the developing device frame 12a is provided
20 with a sticking portion 12a20 to which the end seal 34
is stuck. The sticking portion 12a20 has an arcuate
peripheral surface having a common axis with the
arcuate portion 12a21 provided longitudinally outside
of the arcuate portion 12a6. The axis is the
25 rotational axis of the developing roller 10d in the
toner developing container 12. The sticking portion
12a20 is provided with an arcuate surface having a

radius which is smaller than that of the outer arcuate portion 12a21. An end of the sticking portion 12a20, as shown in Figure 8, ends short of (inside) the circumference of the outer arcuate portion 12a21.

5 As shown in Figures 17, 18, 19, when the lower developing frame is welded to or bonded to the developing device frame 12a, a slit 12d is provided between the arcuate portion 12a6 and the lower developing frame 12b.

10 The slit 12d, as shown in Figures 21 to 23, is on an optical path of a laser beam passing through a gap (development gap) formed between the photosensitive drum 7 and the developing roller 10d provided by the spacer roller 10d1 which is disposed
15 to each of the opposite end portions of the photosensitive drum 7 and the developing roller 10d. Optical path passes through the slit 12d, a slit 10e6 provided in the metal blade 10e2 and a hole 13b1 formed in the cap member 13b.

20 In Figures 21, the laser beam emitted from the laser source 86 has a width which is larger than the gap (approx. 300 μ m) between the photosensitive drum 7 and the developing roller 10d. The laser beam emitted from the laser source 86 travels through the
25 hole 13b1, the slit 10e6, the gap between the photosensitive drum 7 and the developing roller 10d and the slit 12d, and is then received by a

photoreceptor 87. The width of the laser beam received by the photoreceptor 87, measured in a direction parallel with the face of the sheet of the drawing of Figure 21. Therefore, the development gap
5 can be detected.

The measurement of the gap between the photosensitive drum 7 and the developing roller 10d using the laser beam, is effected at each of opposite longitudinal ends of the photosensitive drum 7 (two
10 positions). Therefore, the hole 13b1, the slit and the slit 10e6, 12d are each provided at at least two positions (adjacent opposite longitudinal ends).

After the lower developing frame 12b is welded to the developing device frame 12a, the end
15 seal 34 and the seal 35 are mounted.

As shown in Figure 16, the end seal 34 functions to provide a seal between the developing device frame 12a and each of the end portions of the developing blade 10e and each of the end portions of
20 the developing roller 10d, and it comprises an arcuate portion 34a contactable to the developing roller 10d along its circumferential surface and an integral linear portion 34b along a rear surface of each of the end portions of the metal blade 10e2. The outer
25 circumference of the arcuate portion 34a is stuck to the sticking portion 12a20 of the developing device frame 12a.

As shown in Figure 4, a seal 35 of urethane foam or the like is mounted and extended between blade mounting seat surfaces 12a4 formed above the toner discharging opening 12a1 of the toner discharging, and the developing blade 10e is screwed on the blade mounting seat surface 12a4 with the seal 35 therebetween. By doing so, the seal 35 is compressed between the metal blade 10e2 and a developing device frame 12a so that sealing is accomplished between the metal blade 10e2 and the developing device frame 12a.

The development holder 36 shown in Figures 16, 24 is secured to one of the ends of the developing device frame 12a, and the development holder 37 shown in Figures 16, 25 is secured to the other end thereof. The development holders 36, 37 are fixed to the developing device frame 12a by small screws 56, 57.

The shaft 10d2 of the developing roller 10d at one end is engaged with a fixed bearing 33b which is in the form of a shaft integral with the development holder 37 shown in Figures 15, 16. The developing roller shaft 10d2 is received by a bearing hole 33a2 of the bearing 33a at the other end of the developing roller 10d, and as shown in Figure 15, a hole 33a4 is engaged with a positioning dowel 12a7 provided on the developing device frame 12a at an outside of one of the longitudinal ends. Then, the developing roller gear 10f is engaged with the

developing roller shaft 10d2. The engaging portion 33a3 of the bearing 33a is engaged with a part-cylindrical engaging portion 36a of the development holder 36. At this time, the developing roller gear 10f is accommodated in the development holder 36. A small screw 56 is penetrated through a hole 36c of the development holder 36, a hole 33a1 of the bearing 33a and is threaded into a female screw 12a13 of the developing device frame 12a. The gear accommodating portion 36b outside the development holder 36 is part-cylindrical, and when the toner developing container 12 and a cleaner container 13 are coupled, the developing roller gear 10f is brought into meshing engagement with the drum gear 51a through the open part of the gear accommodating portion 36b.

Each of the development holders 36, 37 is provided with an integral arm portion 38 functioning as a connecting portion for connection did in the toner developing container 12 and the cleaner container 13.

The toner developing container 12 having the various members constituting the developing means and the cleaner container 13 having the various members constituting the photosensitive drum 7, the charging roller 8 and a cleaning means are coupled by the arm portions 38 to constitute the process cartridge B.
(Coupling Between Toner Developing Container and

Cleaner Container)

Referring to Figures 7, 11, 24, 25, 26, the description will be made as to the coupling between the toner developing container 12 and the cleaner container 13. Figures 7 and 11 are a side view and a perspective view illustrating the coupling between the containers 12, 13; Figure 26 shows inside of the coupling portion; and Figures 24, 25 are side views of the copper end portion of the toner developing container 12. The containers 12, 13 are rotatably coupled through the arms 38 at the opposite ends. Since the covering structures at the left and right ends are substantially the same, therefore, the description will be made as to only one end. However, the portions which are different between the left and right hands will be described for the respective ends.

As shown in Figures 11 and 24, the developing device frame 12a is provided with an integral spring mounting portion 12a28, on which a compression coil spring 40 is mounted. The position of the compression coil spring 40 is adjacent one of the longitudinal ends of the developing device frame 12a, and is away from the arm portion 38 in the direction perpendicular to the longitudinal direction. The compression coil spring 40 is extended out in parallel with the arm portion 38. At a free end portion of the arm portion 38 F-1 longitudinal end where the compression coil

spring 40 is provided, a through-hole 38b is provided for receiving a pin 41 which will be described hereinafter. As shown in Figure 26, an outer wall 13q of the cleaner container 13 is provided with a hole 13c for receiving the pin 41, and an inner wall 13d thereof is provided with a hole 13e for being press-fitted by the pin 41. The hole 13c and the hole 13e are aligned along a line parallel with the photosensitive drum 7. An elongated bore 38b1 is formed in the arm portion 38 and the other end of the cleaner container 13, and a line connecting the center of the elongated bore 38b1 and the hole 38b passes through the centers of the holes 13c, 13e. The elongated bore 38b1 is elongated in a direction parallel with a line connecting the center of the photosensitive drum 7 and the center of the developing roller 10d, and a width of the elongated bore 38b1 is equal to the diameter of the pin 41.

When the toner developing container 12 and the cleaner container 13 are coupled together with each other, as shown in Figures 7 and 11, the arm portion 38 of the toner developing container 12 is inserted into the recess 13h of the cleaner container 13, and the pin 41 is penetrated through the hole 13c, 13c of the cleaner container 13, the through hole 38b, of the arm portion 38 and the elongated bore 38b1 in the order named, and is press-fitted into the hole

13e, 13e of the inner wall 13d. By doing so, the toner developing container 12 and the cleaner container 13 are rotatably coupled for rotation about the pin 41. At this time, the compression coil spring 40 mounted to the developing device frame 12a is compressed out the abutment to the spring seat 13f (Figure 26) of the cleaner container 13. The photosensitive drum 7 and the developing roller 10d are urged toward each other about the pin 41 so that spacer rollers 10d1 of the developing roller 10d are press-contacted to the photosensitive drum 7.

Because of the provision of the elongated bore 38b1, the photosensitive drum 7 and spacer rollers 10d1 of the developing roller 10d are contacted to each other at the generating lines thereof. The generating lines are parallel with the center lines of the photosensitive drum 7 and the developing roller 10d.

Figure 7 shows an end surface portion which is opposite from the end where the compression coil spring 40 is provided. Opposite ends of a tension coil spring 59 are engaged with a spring hook 13p of the cleaner container 13 and a spring hook 12a29 of the developing device frame 12a of the toner developing container 12, respectively. The direction of the tension coil spring 59 is substantially parallel with a line connecting the centers of the

photosensitive drum 7 and the developing roller 10d.

By doing so, by the compression coil spring 40 and the tension coil spring 59, the developing roller 10d mounted in the toner developing container 12 is urged toward the photosensitive drum 7 mounted in the cleaner container 13, so that spacer rollers 10d1 at the opposite longitudinal ends of the developing roller 10d are contacted to the photosensitive drum 7 by which the developing roller 10d is correctly position relative to the photosensitive drum 7. The drum gear 51a fix to the end of the photosensitive drum 7 is brought into meshing engagement with the developing roller gear 10f fixed to the and of the developing roller 10d, so that driving force can be transmitted.

(Remanufacturing of Process Cartridge)

(Embodiment 1)

(Separating Step Between Toner Developing Container and Cleaner Container)

The tension coil spring 59 shown in Figure 7 is disengaged from the spring hook 13p of the cleaner container 13.

By doing so, the force between the photosensitive drum 7 and the developing roller 10d is provided only by the compression coil spring 40. Therefore, the toner developing container 12 and the cleaner container 13 are rotatable relative to each

other about the pin 41.

Then, the pin 41 is removed. This is done by pulling out the pin 41 using a plyer or the like if the pin 41 is projected out of the process cartridge

5 B. If not, the pin 41 is pushed into the process cartridge to disengage it.

Thus, the container separating step is completed, by which the toner developing container 12 comprising the toner accommodating portion 10a, the
10 toner supply opening 12a1, the developing roller 10d and the developing blade 10e, and the cleaner container 13 comprising the photosensitive drum 7, are separated from each other by disengaging the pins 41 at one and the other longitudinal ends of the process
15 cartridges B. Figure 11 shows the thus separated toner developing container 12 and cleaner container 13.

(Removing Step of Developing roller)

As shown in Figure 28, the separated toner
20 developing container 12 includes the developing roller 10d and the developing blade 10e mounted thereto.

First, the development holders 36, 37 fix to the opposite end of the developing device frame 12a are removed. The small screw 56 fastening the
25 development holder 36 and the bearing 33a to the developing device frame 12a, as shown in Figure 15, is removed, and the development holder 36 is moved

longitudinally outwardly. Then, the developing roller gear 10f is pulled off the developing roller shaft 10d2. The bearing 33a supporting the developing roller 10d is removed from the shaft 10d2 of the developing roller 10d. The developing roller 10d is pulled in the actual direction to remove it from the bearing 33b of the development holder 37, and the developing roller 10d is removed from the toner developing container 12.

By doing so, the developing roller dismounting step is completed, by which the developing roller 10d mounted to the toner developing container 12 is removed. Figure 14 shows a state in which the developing roller 10d has been removed. When the gear train 61 (Figure 25) for driving the toner feeding member 10b is to be inspected, the development holder 37 is removed from the developing device frame 12a by removing the small screw 57.

(Dismounting Step of Developing Blade)

After the developing roller 10d has been removed, the developing blade 10e is removed. The developing blade 10e is a movement by unthreading the small screws 10e4 which fixes the developing blade 10e to the blade mounting seat surface 12a4 of the developing device frame 12a as shown in Figure 14, and then moving the developing blade 10e away from the blade mounting seat surface 12a4.

Thus, the developing blade dismounting step is completed by which the developing blade 10e mounted to the toner developing container 12 separated by the separation step. Figure 17 is a top plan view showing the toner developing device frame 12a from which the developing blade 10e has been removed. Figure 29 shows the removed developing blade 10e (except for the side pad 65).

Here, all the elements which should be removed from the toner developing device frame 12a have been removed. The drum shutter member 28 is not removed by these retained.

(Application of Sealing Material for Toner Developing Container)

If the toner seal 31 is restored, the remanufactured process cartridge is substantially the same as a new process cartridge. According to the invention, the toner seal 31 is not repaired or restored. Even without the toner seal 31, it will suffice if the toner does not leak when the developing means is mounted to the toner developing container.

(End Seal)

Each or one of the end seals 34 is replaced with new one if it is confirmed as being damaged after inspection.

(Filling Sealing Material into Gap Between Developing Device Frame and Lower Developing Frame)

Between the developing device frame 12a and the lower developing frame 12b, the gap g extends along the inner surface of the end seal 34 at each of the end portions. The gap g is in the form of a crank
5 extending toward the gap g1 as shown in Figure 20, as seen from an outside of the toner developing container 12.

First, the, gaps g and g1 are sealed. This sealing is effected by continuously sticking a
10 developing container cover side seal 62 which is an adhesive tape on an outer periphery of the lower developing frame 12b and the arcuate portion 12a6 as shown in Figure 20 (hatching line) and Figures 30, 32. The sealing covers the entire length of the gaps g and
15 g1 and also covers the slit 12d.

Then, the gap g is filled with a sealing material 64. The sealing material 64 is supplied from the inner side of the arcuate portion 12a6. When the sealing material 64 is filled into the gap g, the
20 sealing material 64 is injected into the gap g at a position which is substantially the middle of the length of the gap using a tool (unshown), and thereafter the sealing material 64 is expanded toward one and the other ends of the length of the gap g,
25 thus filling the sealing material 64 into the gap g in its full length.

The sealing material 64 is plastically

deformable. Examples of such sealing material 64 includes polymeric materials having a curing property or polymeric materials having a thermoplastic property. The selling materials include silicon bond
5 which is polymeric material having a curing property silicone bonding material. The polymeric material having a thermoplastic property includes hot melt plastic resin material.

When the silicon bond is used as the sealing
10 material 64, for example, the sealing material is filled, and it is left for approx. 6 hour, and the cover side seal 62 is removed after it is dried.
(Sticking of Side Pad)

As shown in Figure 33, a gap S diseases
15 between the longitudinal end of the elastic blade 10e1 of the developing blade 10e and the end seal 34. During the image forming operation, the toner does not leak out in the longitudinal direction by the provisions of the end seal 34 despite the existence of
20 the gap S. However, during the transportation, the toner is liable to leak out since the corner portion between the end seal 34 and a seal 35 is a linear portion 34b of the end seal 34 so that it is not in close contact with the developing roller 10d.
25 Therefore, a side pad is provided.

As shown in Figure 29, a side pad 65 (seal) is stuck on the longitudinal surface of the elastic

blade 10e1 of the developing blade 10e at each of the opposite end portions so as to extend beyond the longitudinal end of the blade.

5 The pad is stuck on the backside of the elastic blade 10e1, that is, the side not facing to the developing roller 10d, using an adhesive material. The side pad 65 has such a size that it is compressed into the corner formed by the end seal 34 and a seal 35, so that it is contacted to them by its elasticity,
10 and one side is substantially leveled with the free end of the elastic blade 10e1.

When the developing roller 10d is mounted, the side pad 65 provides sealing between the end seal 34 and the end of the elastic blade 10e1. The side
15 pad 65 is press-contacted to the end seal 34 and to the seal 35.

By doing so, during transportation, the toner is prevented from leaking out through between the developing device frame 12a and the developing blade
20 10e at the opposite ends of the developing roller 10d.

The side pad 65 is mounted on the reused developing blade 10e if the developing blade 10e is reusable. When the developing blade 10e is to be replaced with a new part, the new part developing
25 blade 10e is already provided with the side pad 65.

In this example, the side pad 65 is made of an elastic material such as a sponge.

(End Lateral Seal)

A jaw seal sticking seat surface 12b5 (Figure 4) of the lower developing frame 12b after a jaw seal (blow-preventing seal) 42 is stuck is a flat surface, and extension surface thereof is lower than the extension of the arcuate surface of the inner surface (the surface contacting to the developing roller 10d) of the arcuate portion 34a of the end seal 34. That is, the jaw seal sticking seat surface 12b5 is not flush with the upper surface of the end seal 34. Therefore, when the jaw seal 42 is stuck, a gap remains between the counterpart of the seal 42 at the longitudinal end thereof. The counterpart member is the sealing material 64 having sealed the gap g.

Therefore, an end lateral seal 66 of an elastic member is mounted against the end seal 34 provided at each of one and the other ends of the developing roller 10d at the longitudinally inside of the developing roller 10d and at the opposite side from the side where the toner accommodating portion 10a is provided.

Figure 35 shows an end lateral seal developed into a plane. Figure 36 is a sectional view taken along a line A-A. For the purpose of easy understanding, gaps are shown between members. Actually, however, the members shown in Figure 36 are contacted without gaps. As shown in Figure, the end

lateral seal 66 is stuck to the lower developing frame 12b at the corners of the sealing material 64 and the end seal 34, by adhesive material. As will be described hereinafter, the jaw seal 42 is stuck usually first in the remanufacturing process. By doing so, the end lateral seal 66 is closely contacted to the end seal 34, the sealing material 64 and the lower developing frame 12b. The gap S1 among the jaw seal 42, the lower developing frame 12b and an end lateral seal 66 is reduced by the side cover seal 69 and is sealed from the outside.

As shown in Figures 36, 43, the opposite ends of the jaw seal 42 are overlaid on the end lateral seal 66 and the end seal 34.

With the above-described process, the sealing is provided between the jaw seal 42 and an end seal 34.

(Seal for Slit for Developing Gap Measurement)

As described in the foregoing, the toner sealing is quite completely accomplished by the sealing material 64, the side pad 65, the end lateral seal 66 and the seal 42. However, if the toner were passed through between the jaw seal 42 and the end lateral seal 66, the toner might reach the slit 12d provided in order to assure the optical path for the measurement of the development gap. In view of this, a seal is provided to prevent the toner having reached

the slit 12d from leaking out.

Figure 37 is a front view of the cut-away portion constituting the slit 12d as seen in a direction perpendicular to the longitudinal direction of a developing roller 10d. As shown in Figure 38, the jaw groove filling seal 68 is filled substantially the entire width of the cut-away portion 12d.

The process will be described. As shown in Figures 37, 40, 41, a double-coated adhesive tape or the like is stuck on one surface 68b of a relatively thin rectangular sealing material 68a, and it is stuck on the end of the sealing material 64, the wool felt portion 34c of the end seal 34, the bottom of the cut-away portion 12d substantially flush therewith. The end seal 34 comprises a felt portion 34c and a sliding portion 34d thereon which is made of fibers having a small friction coefficient.

The sealing material 68a is bent by 90° from a corner A where the arcuation of the arcuate portion 12a6 ends (Figure 41) toward outside, by which the slit 12d is substantially closed, as shown in Figure 38. However, the complete closure of the slit is not intended. As shown in Figure 41, if the upper portion of one surface 68b of the sealing material 68a is partly overlapped with the end of the end seal 34, the toner may pass through between the end lateral seal 66 and the jaw seal 42 to reach the slit 12d. It will

suffice if the leakage of such toner is prevented, and therefore, as shown in Figure 40, a gap g2 may be provided between the lateral wall 12d1 of the cut-away portion 12d and the sealing material 38a (side cover seal 69 which will be described hereinafter).

(Mounting of Jaw Seal)

After mounting various seals described in the foregoing, the jaw seal 42 is stuck on the seat surface 12b5. As shown in Figure 42, 43, the jaw seal 42 is stuck. The opposite longitudinal ends of the jaw seal 42 ride on the associated end seals 34 and are bonded thereto by adhesive material. As shown in Figure 45, the free end, extending in the longitudinal direction of the process cartridge, of the jaw seal 42 is pressed against the developing roller codirectionally with respect to the peripheral movement of the surface of the developing roller. (in this embodiment, the new cartridge is not provided with the jaw seal, since the toner in the developer container is confined therein by the seal 31.

(Side Cover Seal)

A side cover seal is provided for the purpose of back-up and toner leakage prevention at a portion where the bent portion of the jaw groove filling seal 68 and end portions of the jaw seal 42 are overlapped with the end lateral seal 66.

As shown in Figure 44, such a surface of the

arcuate portion 12a6 of the developing device frame 12a as is not faced to the developing roller 10d, there is provided a rib 12a36. The lower developing frame 12b is provided with a rib 12b6 which is parallel with the rib 12a36 with the longitudinal gap g between the lower developing frame 12b and the arcuate portion 12a6 of the developing device frame 12a disposed between the ribs. The side cover seal 69 has a width which is equal to the gap between the ribs 12a36 and 12b6 P. The side cover seal 69 is stuck and extended from a position C at a free end (in the direction of a width, that is, perpendicular to the longitudinal direction) of the flange 12a16 (Figures 4 and 8) of the developing device frame 12a the cover the developing device frame 12a and the gap g in the form of a crank, is then folded back over the free end portion D to embrace the groove filling seal 68 and the jaw seal 42 end as shown in Figure 45. By doing so, the jaw seal 42 at a longitudinal extension of the jaw seal sticking seat surface 12b5 of the lower developing frame 12b is closely contacted to the jaw groove filling seal 68, and the jaw seal 42 is not easily removed from the sticking seat surface 12b5 at an edge of a side surface of the seal 68.

25 (Mounting of Developing Blade)

When a developing device frame 12a is deformed, for example, a gap is produced between the

metal blade 10e2. Here, the seal 35 is long,
therefore, the sealing property is relatively not very
good. In view of this, a re-assembling of this
embodiment will be described according to which the
5 performance of the toner developing container 12 is
substantially the same as a new one.

A seal is provided in addition to the seal 35
in consideration of the case that sealing property of
the seal 35 of the toner developing container 12 is
10 deteriorated.

The developing blade 10e having been removed
is subjected to simultaneous air suction and air blow,
or the like such that deposited toner is removed from
the blade to clean it.

15 Then, the developing blade 10e is inspected
to determine whether it is reusable or not. If the
result of the inspection indicates that performance
thereof is lower than a predetermined standard, it is
replaced with a new one.

20 Between the blade mounting seat surfaces 12a4
at the opposite ends of the developing device frame
12a, a flange is provided, which is provided with a
mounting seat 12a3.

The bent portion 10e3 of the metal blade 10e2
25 of the developing blade 10e shown in Figure 16 is
urged toward the seat 12a3 of the flange of the
developing device frame 12a with the seal 35

compressed there between, and the holes 10e7 of the metal blade 10e2 are fitted around the positioning dowels 12a11 provided on the developing blade mounting seat surface 12a4. Then, a small screw 10e4 (only one
5 longitudinal end portion of the metal blade 10e2 is shown) is threaded into the developing blade mounting seat surface 12a4 through the hole 10e7 provided adjacent each of the opposite longitudinal ends of the metal blade 10e2 so that developing blade 10e is fixed
10 to the developing device frame 12a.

This is the end of the developing blade mounting step to the separated toner developing container 12.

(Developing Roller Mounting Step)

15 The developing roller 10d which has been removed is subjected to the air suction and simultaneous air blowing or another process to clean it by removing the deposited toner.

Then, the developing roller 10d is inspected,
20 and it is determined whether or not it is reusable. If the determination is negative, that is, the performers does not satisfy a predetermine reference, the developing roller is replaced with a new one.

The developing roller 10d may be worn due to
25 the friction with the developing blade 10e. Therefore, when the statistic probability that replacement is necessary on the basis of the

inspections during development thereof or remanufacturing thereof, the developing roller may be replaced with a new one without the inspection, and by doing so, the remanufacturing operation is efficient.

5 In the inspection of the developing roller 10d, it is disassembled into the main body of the developing roller, the magnet 10c, the bearings 33a, 33b, spacer rollers 10d1 roller electrode (unshown), the developing roller gear 10f and so on are
10 inspected, respectively, to find reusable parts. The non-reusable parts are replaced with new ones.

 As for the gear train 61 for driving the toner feeding member 10b rotatably supported on the developing device frame 12a and the lower developing
15 frame 12b, the development holder 37 is removed, and the gear train is cleaned and inspected, and is replaced with an usable parts, and they are reassembled prior to the assembling of the used or new developing roller 10d.

20 Referring to Figures 15 and 16, the process of mounting the developing roller 10d to the toner developing container 12 will be described.

 The development holder 37 is engaged to the developing device frame 12a. A small screw 57 is
25 threaded into the developing device frame 12a through the development holder 37 so that development holder 37 is fixed to the developing device frame 12a. Then,

a journal hole at an end of the developing roller 10d is engaged with a bearing 33b of the development holder 37. Subsequently, at a longitudinal end which is opposite from the bearing 33b, the bearing 33a is engaged in the journal at the other end of the developing roller 10d, and the bearing 33a is aligned with the developing device frame 12a. Into a D-shaped shaft portion provided at the journal end of the developing roller 10d projected outwardly beyond the bearing 33a, the developing roller gear 10f having a hole which has the complementary shape and size. Then, the engaging portion 36a of the development holder 36 is engaged with a cylindrical engaging portion 33a3 of the bearing 33a. At this time, one end of the magnet 10c is engaged with a D-shaped hole 36d which is provided longitudinally outwardly beyond the bearing hole. The shaft portion at the end of the magnet 10c has the complementary shape and size with the D-shaped hole 36d. Then, a small screw 56 is threaded into a female screw 12a13 of the developing device frame 12a through the hole 36c of the development holder 36 and the hole 33a1 of the bearing 33a. By doing so, the development holders 37, 36 are fixed to the developing device frame 12a, and the developing roller 10d is supported by the toner developing container.

This is the end of the process of mounting

the developing roller 10d to the separated toner developing container 12.

The toner developing container 12 to which the developing roller 10d is mounted is shown in Figure 11. A new toner developing container 12 have a remanufactured toner developing container 12 are the same as seen in the direction shown in Figure 11. (Developing Blade Top Seal)

If the toner developing container 12, particularly, the surface on which the seal 35 is stuck this deformed during transportation, a gap is formed between the metal blade 10e2 and the seal 35. So, there is a liability that toner leaks between the longitudinal end edge of the metal blade 10e2 and the developing device frame 12a.

In view of this, as shown in Figure 46, a seal is stuck on the outside of the toner developing device frame 12a over the metal blade 10e2 and the cap member 12c. The seal is called here a blade top seal 49. As shown in Figure 29, a scraper 60 is fixed to the metal blade 10e2. The free end 60a of the scraper 60 is contacted to the developing roller 10d by its elastic force. The free end 60a is inclined relative to the generating line of the developing roller 10d.

The inclining direction of the free end 60a downstream with respect to the peripheral movement of the developing roller 10d toward the longitudinally

inside. By doing so, the toner deposited on the developing roller 10d is prevented from moving in the longitudinally outward direction, so that toner returns from the end of the jaw seal 42 into between
5 the jaw seal 42 and the developing roller 10d.

A longitudinal end of the blade top seal 49 stuck on the metal blade 10e2 and the cap member 12c such that it closes the gap between the metal blade 10e2 and the cap member 12c in the longitudinal
10 direction, is within a range where the scraper 60 exists.

By doing so, the seal sticking step for sticking the seal for preventing the toner from leaking, over the metal late portion of the developing
15 blade 10e and the toner developing container 12 is completed.

The seal sticking step may be carried out immediately after the developing blade 10e is mounted to the toner developing container 12.

20 The blade top seal 49 is an adhesive tape.
(Toner Filling Step)

Toner is filled into the toner developing device frame 12a which has been sealed at various positions described above, through the toner filling
25 opening 12a2, and a toner cap 32 or plug is press-fitted into the toner filling opening 12a2 to seal it.

In an alternative of the method, the toner

may be filled before the developing blade 10e and the developing roller 10d are remounted. In such a case, as shown in Figure 56, the toner developing container 12 is placed with the toner supply opening 12a1 faced up and the toner accommodating portion 10 a at a lower position. A free end of a funnel 47 is inserted into the opening 12a1, and the toner the is let fall from the toner bottle 48 onto the funnel 47. After the toner filling, the developing blade 10e and the developing roller 10d are remounted in the same manner as with the case described above. A metering supplying device provided with an auger may preferably provided in the funnel, since then the toner can be efficiently supplied.

Thus, the toner filling step into the toner accommodating portion 10a through the toner supply opening 12a1 is completed.

The toner does not leak out through the gap g in the form of a crank at the end portions of the developing device frame 12a and the lower developing frame 12b because of the sealing material 64 provided as described hereinbefore.

The toner end lateral seal 66 is effective to prevent the leakage which may otherwise occur between the jaw seal (blow-out preventing seal) 42 and the end seal 34.

In addition to the end lateral seal 66, the

jaw groove filling seal 68 is effective to seal the end of the end seal 34, and further, the side cover seal 69 is effective to back up the sealing function of the jaw seal 42 and the end seal 34, so that toner leakage is further prevented.

Moreover, a side pad 65 stuck on the elastic blade 10e1 of the developing blade 10e is contacted to the corner formed between the seal 35 and the end seal 34, and therefore, the longitudinal end of the elastic blade 10e1 is closely contacted to the developing roller 10d, and is sealed by the side pad 65, the toner is prevented from leaking out of the longitudinal ends of the elastic blade 10e1.

Therefore, no toner is leaked out of the inside of the toner developing container 12 having the developing roller 10d and the developing blade 10e during normal transportation and handling.

(Coupling of Toner Developing Container and Cleaner Container)

The coupling step for the toner developing container 12 and the cleaner container 13 is similar to the coupling for the toner developing container 12 and the cleaner container 13 having the toner seal. Therefore, the description will be made in conjunction with Figures 11, 7, 26.

In Figure 11, the arm portions 38 of the toner developing container 12 are inserted into the

recesses 13h of the cleaner container 13. As shown in Figure 26, the through hole 38 b and the elongated bore 38b1 of the arm portion 38 are aligned with the holes 13c on the outer wall surface 13q of the cleaner container 13. When the hole 13c and the through hole 38b and the elongated bore 38b1 are aligned, the through hole 38 b and the elongated bore 38b1 are aligned with the holes 13e in the surface 13d of the inner wall of the cleaner container 13. Then, the pin 41 is inserted through the holes 13c of the cleaner container 13 and the hole 38 b and the elongated bore 38b1 of the arm portion 38 of the toner developing container 12. Further, the pin 41 is press-fitted into the hole 13e in the inner wall of the cleaner container 13. As shown in Figure 7, the end portions of the tension coil spring 59 are hooked on the spring hook 12a29 of the toner developing container 12 and the spring hook 13p of the cleaner container 13, thus the tension coil spring 59 is stretched. By this, the photosensitive drum 7 is press-contacted to the spacer rollers 10d1 at the end portions of the developing roller 10d.

In this manner, the remanufacturing of the process cartridge is possible without remounting of the toner seal 31.

(Remanufacturing of Cleaner Container)

During the remanufacturing of the toner

developing container 12, the separated cleaner container 13 is remanufactured.

Figure 11 is a perspective view showing the cleaner container 13 having the photosensitive drum 7, charging roller 8, cleaning blade 11a. Figure 47 is a longitudinal sectional view wherein the photosensitive drum 7 is mounted to the cleaner container 13. Figure 48 shows a structure for supporting the charging roller 8 on the cleaner container 13.

As shown in Figure 47, the photosensitive drum 7 is provided at one end of the drum cylinder 7a (hollow aluminum cylinder) having a photosensitive layer thereon with a flange 51 and is provided at the other end with a flange 52. The flanges are fixed to the drum by bonding or crimping. The flange 51 is provided with a drum gear 51a. The flange 52 has a transfer roller driving gear 52a. The drum shafts 53a, 53b penetrating the flanges 51, 52, are received by holes 13k, 13m of the cleaner container 13 and are supported by the cleaner container 13. When the process cartridge B is mounted to the main assembly 14 of the image forming apparatus, the drum gear 51a is brought into meshing engagement with the driving gear 22 of the main assembly 14 of the image forming apparatus shown in Figure 2, and the transfer roller driving gear 52a is brought into meshing engagement with the unshown gear fixed to the transfer roller 4.

When the coupling between the cleaner container 13 and the toner developing container 12 is completed, the drum gear 51a is engaged with the developing roller gear 10f of the developing roller 10d.

5 As shown in Figure 48, the charging roller 8 comprises a metal shaft 8a and a rubber roller thereon having an intermediate resistance, and the metal shaft 8a is exposed at the end portions.

10 As shown in Figure 48, the shaft 8a of the charging roller 8 is rotatably engaged in charging roller bearings 8c which is slidably engaged in the guide groove 13g extended substantially on a line connecting the centers of the photosensitive drum 7 and the charging roller 8. The charging roller
15 bearing 8c is urged toward the photosensitive drum 7 by the compression coil spring portion 8b which is compressed between the charging roller bearing 8c and the spring seat 13s at one end of the guide groove 13g, so that charging roller 8 is press-contacted to
20 the photosensitive drum 7. The charging roller 8 is driven by the photosensitive drum 7. The compression coil spring 8b is holded in the bearing 8c.

25 An unshown electrode is contacted to the metal shaft 8a of the available from charging roller 8, and is extended to an outside of the process cartridge B. The outer contact portion of the electrode is electrically connected with a contact

portion of the main assembly 14 of the image forming apparatus which is connected with an outer contact portion in the main assembly.

The cleaning blade 11a, as shown in Figure 4, comprises a metal blade 11a2 and an elastic blade 11a1 of rubber or the like fixed to the metal blade 11a2 and contacted to the photosensitive drum 7 along a generating line thereof. As shown in Figure 4, the cleaning blade 11a is fixed to the cleaner container 13 by threading a small screw 11a4 through a hole at the end portions of the metal blade 11a2.

The description will be made as to dismounting of the photosensitive drum 7, the charging roller 8 and the photosensitive drum 7 from the cleaner container 13.

The photosensitive drum 7 is dismounted from the cleaner container 13 when the shafts 53a, 53b are pulled out of the center holes 51b, 52b of the flange 51, 52 flanges 51, 52, shown in Figure 47.

When the photosensitive drum 7 is dismounted, the charging roller 8 is moved in a direction perpendicular to axis, so that bearings 8c are moved along the guide groove 13g, by which the bearing 8c is dismounted from the guide groove 13g together with the charging roller 8. The bearing 8c is disengaged from the shaft 8a, and the compression coil spring 8b is dismounted. In this manner, an opening G between the

cleaning blade 11a and the receptor sheet 11b and extending in the longitudinal direction appears (Figure 4).

5 The removed photosensitive drum 7, the charging roller 8c and the bearings 8c, are subjected to inspections to determine whether to reuse or not, and if it should be reused, it is assembled into the cleaner container 13 in the reassembling operation which will be described hereinafter, and if not, a new
10 part or parts are used. Usually, however, the photosensitive drum 7 has such a long lifetime that it is still usable at the time when the toner is used up. (Removal of Residual Toner in Cleaner Container)

15 The residual toner in the cleaner container 13 is removed after the photosensitive drum 7, the charging roller 8, the bearing 8c and the like are removed.

Referring to Figures 49, 50, 51, the description will be made as to the removal of the
20 toner contained in the removed toner accommodating portion 11c of the cleaner container 13.

Figure 49 shows a cleaning device for the cleaner container. The cleaner container 13 is set in a casing 70a of the cleaning device 70. The casing
25 70a seals the inside against the atmosphere. The cleaner container 13 is impacted by an impacting device 77 which is carried on the pivoting device 73,

and the residual toner is sucked out of the set by a suction device 79. Simultaneously, the cleaner container 13 is swung about a shaft 76b by a swing device 73.

5 Figure 50 shows details of an air block 79a of the suction device 79. The air block 79a is generally hollow, and has a close contact surface 79g to be contacted to the edge of the opening G of the cleaner container 13, the close contact surface 79g
10 being coated with a rubber-like seal member 79b except for the ejection opening 79d and the suction opening 79e. An air supply tube 79c for supplying the air into the cleaner container 13 is disposed in the air block 79a, and an air blow opening 79d opens adjacent
15 a longitudinal end of the above-described close contact surface 79g. Furthermore, a suction tube 79f is disposed in the air block 79a, and the suction opening 79e of the suction tube 79f is disposed adjacent the other end of the close contact surface
20 79g. The close contact surface 79g having the air blow opening 79d and the suction opening 79e is contacted to the cleaning blade 11a and the receptor sheet 11b of the cleaner container 13 which has been moved in the direction of arrow K3 to a cleaning
25 position M2 by a table 72, so that in the opening G between the edges of them are completely covered. This is indicated by chain lines in the opening G in

Figure 50, more particularly, the sealing range A1, air blowing opening A2 and the air discharging outlet A3. The sealing range A1, the air blowing opening A2 and the air discharging outlet A3 corresponds to the

5 close contact surface 79g, the air blow opening 79d and the suction opening 79e, respectively. In the suction device 79, compressed air Q1 is supplied into the cleaner container 13 closely contacted to the air block 79a from the air supply tube 79c through the air

10 blow opening 79d closely contacted to the air blowing opening A2 and through the opening G (arrow Q2) to scattering the residual toner; and the residual toner and the air are sucked from the cleaner container 13 through the suction opening 79e closely contacted to

15 the air discharging outlet A3 (arrow Q3) into the suction tube 79f (arrow Q4).

The residual toner leaked out of the air block 79a and cleaner container 13, is sucked by an auxiliary suction device (unshown) with the atmosphere

20 in the suction device 75 through the ambience suction opening 78, as shown in Figure 49.

Referring to Figures 49 and 50 and a flow chart of Figure 51, the description will be made as to the cleaning method of the cleaner container 13 and

25 the operation of the cleaning device 70 in detail.

The operation of the cleaning device (cleaner) 70 is started at step (S1). Then, the

cleaner container 13 to be cleaned is placed on the top of a table 72 which is at a home position at this time (S2). The cover 70b is closed (S3), which event is detected by a sensor (door switch) 70d (S4), and an
5 air cylinder of a clamping device (unshown) is actuated (S5), by which the top side of the cleaner container 13 is pushed.

By this, the cleaner container 13 is clamped on the table 72 at a predetermined position. An air
10 cylinder 75 having a piston rod directly connected to the table 72 is actuated (S7), so that table 72 moves from the home position M1 on the slide base 71 to a cleaning position M2 in the swing device 73 (S8), and the opening G of the cleaner container 13 is closely
15 contacted to the surface 79g of the suction device 79.

Then, a motor 77a is actuated (S9), and the impacting device 77 is started, by which the pin 77b of the crank to which the shaft of the motor 77a is fixed is swung about a pin 77d supporting the yoke
20 77c. Impact is applied to a point P (Figure 50) on the top side of the cleaner container 13 by a hammer 77g fixed to an end of the leaf spring arm 77e fixed to the yoke 77c (S10). By doing so, the residual toner deposited on the inner wall of the cleaner
25 container 13 is forced to fall, and the mobility of the residual toner is enhanced. A rotary actuator 76 is started (S11), and the swing table 73a of the swing

device 73 reciprocate about a shaft 76b swingably supporting the swing table 73a within the range of $\alpha = 0-80^\circ$. The swing table 73a is stopped by abutting stoppers 71a, 71b, positions of which are adjustable.

5 A stop valve (unshown) for the compressed air is opened (S13, S14) to supply the compressed air into the cleaner container 13 through the air blow opening 79d (Figure 50) and the opening G, and simultaneously, the air in the cleaner container 13 is sucked through
10 the opening G and the suction opening 79e together with the residual toner. The operation is continued for a proper period.

The swing table 73a is swung through one reciprocation (S15). A rotary actuator 76 is
15 deactivated (S16), and the horizontal position N1 of the swing table 73a is checked (S17), and then, the motor 77a is deactivated (S18, S19), so that impact imparted by the hammer to the position N1 ends. The stop valve is closed (S20, S21). The air cylinder 75
20 is urged in the resetting direction (S22), and then, the table 72 located at the cleaning position M2 is returned to the home position M1. In response this, an unshown clamping air cylinder is deactivated (S24), and the clamp of the cleaner container 13 relative to
25 the table 72 is released (S25). Then, the cover 70b is opened (S26), and the cleaner container 13 is taken out of the casing 70a (S27). This is the end of the

cleaning operation for the cleaner container 13.

In the cleaning step, the impact to the cleaner container 13 by the device 77 continues in the period between the steps S9 and S18 in the flow chart of Figure 51, and contemporaneously therewith, the swing action of the cleaner container 13 and the suction of the residual toner are carried out. Thus, the residual toner deposited on the inner wall or the like of the cleaner container 13 are beaten out, and the residual toner is smoothly moved toward the opening G. The compressed air blown out from the air blow opening 79d is effective to scatter around in the cleaner container 13, and the residual toner is sucked from the suction opening 79e. By the series of the operations, the residual toner can be substantially completely removed from the cleaner container 13.

After the cleaning, the cleaning blade 11a is removed from the cleaner container 13 by unthreading the small screw 11a4 (Figure 4). Then, the receptor sheet 11b is removed from the cleaner container 13. Then, while sucking the air from the inside of the cleaner container 13, compressed air is blown into the cleaner container 13, thus cleaning the inside of the cleaner container 13. Thereafter, a new receptor sheet 11b is stuck on the cleaner container 13. Holes 11a3 of a new cleaning blade 11a at the end portions (Figure 11 shows only one end portions) are brought

into engagement with the positioning projections 13i of the cleaner container 13, and small screw 11a4 is threaded into the cleaner container 13 through the hole of the metal blade 11a2.

5 Then, a charging roller 8 engaged with the bearings 8c to which the compression coil springs 8b are mounted, is mounted on the shaft 8a. This is done by engaging the bearing 8c into the guide groove 13g with the compression coil spring 8b at the leading
10 side. Thereafter, as shown in Figures 47, the photosensitive drum 7 is engaged between the end walls of the cleaner container 13, and the center holes 51b, 52b of the flanges 51, 52 are aligned with holes 13k, 13m in the end walls at the opposite ends of the
15 cleaner container 13, and then, the drum shafts 53a, 53b are engaged into the holes 13k, 51b, 52b, 13m. The drum shafts 53a, 53b are press-fitted in the holes 13m, 13k, and the drum shafts 53a, 53b are slidably engaged in the holes 51b, 52b. The photosensitive
20 drum 7 in the unit is rotatable on the drum shafts 53a, 53b.

(Gap between Photosensitive Drum and Developing Roller)

25 When the photosensitive drum 7 and the developing roller 10d are contacted to each other, the drum gear 51a and the developing roller gear 10f are in meshing engagement with each other. When the

process cartridge is transported with the drum gear 51a and the developing roller gear 10f are in meshing engagement with each other, the tooth surfaces of the gears are in contact, and therefore, they may be
5 rotated by impact or vibration. If the direction of the rotation is as indicated by an arrow A in Figure 52 (the same direction as in the image forming operation), there is no problem. However, the direction of the rotation is not assured, since the
10 vibration or the impact during the transportation occurs at random. If the photosensitive drum 7 rotates in the direction indicated by an arrow B, that is, if the photosensitive drum 7 and the developing roller 10d are rotated in the direction opposite from
15 the normal direction, the toner may be leaked out through between the jaw seal 42 (blow-out preventing sheet) and the developing roller 10d, and in the worst-case, the seal 42 may be wound around the developing roller since the preventing sheet is
20 contacted to the developing roller counter-directionally. In addition, the scraper 60 mounted to each of the opposite ends of the developing blade 10e and functioning to guide the toner inwardly at the opposite ends of the developing roller 10d can operate
25 correctly when the developing roller 10d rotates in the mall direction, and therefore, if it is rotated in the wrong direction, the toner may leak out at the

opposite ends of the developing roller 10d.

In this embodiment, the back clearance of the meshing between the drum gear 51a and the developing roller gear 10f is made larger than that during the image formation to avoid abutment between the tooth surfaces during the transportation. Another alternative is to disengage them for the transportation.

Referring to Figure 54, the description will be made as to means for maintaining the disengaged state or large back clearance between the drum gear 51a and the developing roller gear 10f. In the case of Figure 53, a tape 81 is stuck over the toner developing container 12 and the cleaner container 13 with the drum gear 51a and the developing roller gear 10f disengaged from each other or with the large back clearance.

More particularly, a force is applied to the toner developing container 12 and the cleaner container 13 toward each other and positions across a vertical surface passing through a point P which is a pivot between the toner developing container 12 and the cleaner container 13 from the portion where the photosensitive drum 7 and the developing roller 10d are provided, as indicated by an arrow N in Figure 53, by which the back clearance between the drum gear 51a and the developing roller gear 10f is increased, or

they are disengaged from each other. The force is against the spring force provided by the tension coil spring 59 (Figure 7) and the compression coil spring 40 (Figure 11) for urging the photosensitive drum 7 and the developing roller 10d toward each other. Therefore, the tape 81 is stretched by the springs 40, 59. Therefore, the tape 81 has sufficient width and thickness such that stress during the transportation is within a tolerable range, and in addition, the adhesive material or the adhesive material for the tape has also sufficient bonding strength against the toner developing device frame 12a and the cleaner container 13.

The foregoing embodiments are summarized as follows.

1. A remanufacturing method of remanufacturing a process cartridge B comprising:

(a) a step of preparing a used process cartridge B which comprises a toner developing container 12, a cleaning container 13 and pins for coupling said toner developing container 12 and said cleaning container 13 at opposite longitudinal ends of said process cartridge B,

said toner developing container 12 including a toner accommodating portion 10a, a toner supply opening 12a1, a developing roller 10d and a developing blade 10e;

said cleaning container 13 including an electrophotographic photosensitive drum 7;

(b) a container separating step of separating said process cartridge B into said toner developing container 12 and said developing container by
5 disengaging said pins from said process cartridge B;

(c) a developing roller 10d dismounting step of dismounting said developing roller 10d from said toner developing container 12 separated by said
10 container separating step;

(d) a developing blade 10e dismounting step of dismounting said developing blade 10e from said toner developing container 12 separated by said container separating step;

(e) an elastic member 66 mounting step of mounting an elastic member 66 to a longitudinally inside of an end seal 34 provided adjacent each of opposite longitudinal ends of a or said developing roller 10d, at a position laterally outside of said
15 end seal 34;
20

(f) a developing blade 10e mounting step of mounting a or said developing blade 10e on a or said toner developer container;

(g) a developing roller 10d mounting step of mounting a or said developing roller 10d on said toner developer container having said developing blade 10e;
25

(h) a toner refilling step of refilling the

toner into a or said toner accommodating portion 10a of said toner developing container 12 having said developing blade 10e and said developing roller 10d; and

5 (i) a container coupling step of coupling said toner developing container 12 having said developing blade 10e and said developing roller 10d with a or said cleaning container 13 by engaging a or said pin 41 into them.

10 By this, even if the mounting seat for the seal 42 is not leveled with the top surface of the end seal 34, the gap between the toner developing container 12 and the seal 42 can be minimized to prevent the leakage of the toner through such a gap,
15 at the longitudinal end of the seal 34.

2. A method according to Paragraph 1, further comprising a flexible sheet 42 mounting step of mounting, after said cut-away portion 12d sealing step and before said toner refilling step, a flexible sheet
20 42 to said toner developing container 12 so as to extend along the longitudinal direction of said developing roller 10d when said developing roller 10d is mounted to said toner developing container 12.

3. A method according to Paragraph 2, wherein in
25 said flexible sheet 42 mounting step, each of longitudinal ends of said flexible sheet 42 extends over a surface of said elastic member 66 and a part of

said end seal 34.

By this, the gap between the flexible sheet 42 and the end seal 34 is sealed effectively.

4. A method according to Paragraph 2 or 3,
5 further comprising first and second side seal 64
mounting step of mounting, after said flexible sheet
42 mounting step, a first side seal 64 continuously on
a longitudinal end of said flexible sheet 42 mounted
on said toner developing container 12 and said toner
10 developing container 12, and a second side seal 64
continuously on the other longitudinal end of said
flexible sheet 42 and said toner developing container
12.

By this, at a longitudinal extension of a
15 portion of the seal 42 at reach it is stuck on the
toner developing container 12, the bent portion of the
seal 68 is backed up, so that the toner leakage is
effectively prevented.

5. A remanufacturing method of remanufacturing a
20 process cartridge B comprising:

(a) a step of preparing a used process
cartridge B which comprises a toner developing
container 12, a cleaning container 13 and pins for
coupling said toner developing container 12 and said
25 cleaning container 13 at opposite longitudinal ends of
said process cartridge B;

said toner developing container 12 including

a toner accommodating portion 10a, a toner supply opening 12a1, a developing roller 10d and a developing blade 10e;

5 said cleaning container 13 including an electrophotographic photosensitive drum 7;

(b) a container separating step of separating said process cartridge B into said toner developing container 12 and said developing container by disengaging said pins from said process cartridge B;

10 (c) a developing roller 10d dismounting step of dismounting said developing roller 10d from said toner developing container 12 separated by said container separating step;

15 (d) a developing blade 10e dismounting step of dismounting said developing blade 10e from said toner developing container 12 separated by said container separating step;

20 (e) an elastic member 66 mounting step of mounting an elastic member 66 to a longitudinally inside of an end seal 34 provided adjacent each of opposite longitudinal ends of a or said developing roller 10d, at a position laterally outside of said end seal 34;

25 (f) a flexible sheet 42 mounting step of mounting a flexible sheet 42 to a or said toner developing container 12 so as to extend along the longitudinal direction of said developing roller 10d

when said developing roller 10d is mounted to said toner developing container 12;

(g) first and second side seal 64 mounting step of mounting a first side seal 64 continuously on a longitudinal end of said flexible sheet 42 mounted on said toner developing container 12 having the flexible sheet 42 and said toner developing container 12 having the flexible sheet 42, and a second side seal 64 continuously on the other longitudinal end of said flexible sheet 42 and said toner developing container 12 having flexible sheet 42;

(h) a developing blade 10e mounting step of mounting a or said developing blade 10e on said toner developer container having the flexible sheet 42;

(i) a developing roller 10d mounting step of mounting a or said developing roller 10d on said toner developer container having the flexible sheet 42;

(j) a toner refilling step of refilling the toner into a or said toner accommodating portion 10a of said toner developing container 12 having said flexible sheet 42; and

(k) a container coupling step of coupling said toner developing container 12 having said flexible sheet 42 with a or said cleaning container 13 by engaging a or said pin 41 into them.

By this, the toner leakage is prevented even without a seal for the toner supply opening 12a1.

6. A method according to Paragraph 1 or 5,
wherein said elastic member 66 is mounted on a side of
said end seal 34.

By this, not only the toner leakage through
5 between the seal 42 and the toner developing container
12 at the longitudinal end of the seal 42 but also the
toner leakage through between the seal 66 and the end
seal 34, are prevented. The contact of the seat 66
to the end seal 34 is particularly preferable from
10 the standpoint of preventing the leakage of the toner
moved along the developing roller 10d.

7. A method according to any one of Paragraphs 1
to 6, wherein said seal is made of a plastically
deformable material.

15 By this, the sealing property of the elastic
member 66 is good.

8. A method according to any one of Paragraphs 1
to 7, wherein said toner refilling step is carried out
through a toner filling opening after said elastic
20 member 66 mounting step, said developing blade 10e
mounting step and said developing roller 10d mounting
step.

By this, the toner filling equipment for
producing new cartridges can be used for refilling the
25 toner.

9. A method according to any one of Paragraphs 1
to 8, wherein in said developing blade 10e mounting

step, a new developing blade 10e or a used developing blade 10e is mounted.

10. A method according to any one of Paragraphs 1 to 9, wherein in said developing roller 10d step, a
5 new or used developing roller 10d is mounted.

11. A method according to any one of Paragraphs 1 to 10, wherein prior to said container coupling process, said electrophotographic photosensitive drum 7 and said cleaning blade are dismounted from said
10 cleaner container, and toner which has been removed from said electrophotographic photosensitive drum 7 and accommodated in said cleaner container, is removed.

12. A method according to Paragraph 11, wherein
15 after the toner is removed, a new or used electrophotographic photosensitive drum 7 and a new or used cleaning blade are mounted.

13. A method according to any one of Paragraphs 1 to 12, wherein said remanufacturing method is
20 implemented with a toner seal for sealing a toner supply opening 12a1 provided to supply the toner accommodated in said toner accommodating portion 10a to said developing roller 10d having been pulled out to supply t toner accommodated in said toner
25 accommodating portion 10a to said developing roller 10d.

14. A remanufacturing method of remanufacturing a

process cartridge B comprising:

5 (a) a step of preparing a used process cartridge B which comprises a toner developing container 12, a cleaning container 13 and pins for coupling said toner developing container 12 and said cleaning container 13 at opposite longitudinal ends of said process cartridge B;

10 said toner developing container 12 including a toner accommodating portion 10a, a toner supply opening 12a1, a developing roller 10d and a developing blade 10e;

said cleaning container 13 including an electrophotographic photosensitive drum 7;

15 (b) a container separating step of separating said process cartridge B into said toner developing container 12 and said developing container by disengaging said pins from said process cartridge B;

20 (c) a developing roller 10d dismounting step of dismounting said developing roller 10d from said toner developing container 12 separated by said container separating step;

25 (d) a developing blade 10e dismounting step of dismounting said developing blade 10e from said toner developing container 12 separated by said container separating step;

(e) an elastic member 66 mounting step of mounting an elastic member 66 to a longitudinally

inside of an end seal 34 provided adjacent each of opposite longitudinal ends of a or said developing roller 10d, at a position laterally outside of said end seal 34;

5 (f) a developing blade 10e mounting step of mounting a or said developing blade 10e on a or said toner developer container;

(g) a developing roller 10d mounting step of mounting a or said developing roller 10d on said toner
10 developer container having said developing blade 10e;

(h) a toner refilling step of refilling the toner into a or said toner accommodating portion 10a of said toner developing container 12 having said developing blade 10e and said developing roller 10d,
15 through the toner supply opening 12a1 of said toner developing container 12 having said seal; and

(i) a container coupling step of coupling said toner developing container 12 having said developing blade 10e and said developing roller 10d
20 with a or said cleaning container 13 by engaging a or said pin 41 into them.

15. A method according to Paragraph 14, further comprising a flexible sheet 42 mounting step of mounting, after said cut-away portion 12d sealing step
25 and before said toner refilling step, a flexible sheet 42 to said toner developing container 12 so as to extend along the longitudinal direction of said

developing roller 10d when said developing roller 10d is mounted to said toner developing container 12.

16. A method according to Paragraph 15, wherein in said flexible sheet 42 mounting step, each of
5 longitudinal ends of said flexible sheet 42 extends over a surface of said elastic member 66 and a part of said end seal 34.

17. A method according to Paragraph 15 or 16, further comprising first and second side seal 64
10 mounting step of mounting, after said flexible sheet 42 mounting step, a first side seal 64 continuously on a longitudinal end of said flexible sheet 42 mounted on said toner developing container 12 and said toner developing container 12, and a second side seal 64
15 continuously on the other longitudinal end of said flexible sheet 42 and said toner developing container 12.

18. A remanufacturing method of remanufacturing a process cartridge B comprising:

20 (a) a step of preparing a used process cartridge B which comprises a toner developing container 12, a cleaning container 13 and pins for coupling said toner developing container 12 and said cleaning container 13 at opposite longitudinal ends of
25 said process cartridge B;

said toner developing container 12 including a toner accommodating portion 10a, a toner supply

opening 12a1, a developing roller 10d and a developing blade 10e;

said cleaning container 13 including an electrophotographic photosensitive drum 7;

5 (b) a container separating step of separating said process cartridge B into said toner developing container 12 and said developing container by disengaging said pins from said process cartridge B;

10 (c) a developing roller 10d dismounting step of dismounting said developing roller 10d from said toner developing container 12 separated by said container separating step;

15 (d) a developing blade 10e dismounting step of dismounting said developing blade 10e from said toner developing container 12 separated by said container separating step;

20 (e) an elastic member 66 mounting step of mounting an elastic member 66 to a longitudinally inside of an end seal 34 provided adjacent each of opposite longitudinal ends of a or said developing roller 10d, at a position laterally outside of said end seal 34;

25 (f) a flexible sheet 42 mounting step of mounting a flexible sheet 42 to a or said toner developing container 12 so as to extend along the longitudinal direction of said developing roller 10d when said developing roller 10d is mounted to said

toner developing container 12;

(g) first and second side seal 64 mounting
step of mounting a first side seal 64 continuously on
a longitudinal end of said flexible sheet 42 mounted
5 on said toner developing container 12 having said
flexible sheet 42 and said toner developing container
12 having said flexible sheet 42, and a second side
seal 64 continuously on the other longitudinal end of
said flexible sheet 42 and said toner developing
10 container 12 having said flexible sheet 42;

(h) a developing blade 10e mounting step of
mounting a or said developing blade 10e on said toner
developer container having the flexible sheet 42;

(i) a developing roller 10d mounting step of
15 mounting a or said developing roller 10d on said toner
developer container having said flexible sheet 42;

(j) a toner refilling step of refilling the
toner into a or said toner accommodating portion 10a
of said toner developing container 12 having said
20 flexible sheet 42, said developing blade 10e and said
developing roller 10d, through the toner supply
opening 12a1 of said toner developing container 12
having said flexible sheet 42; and

(k) a container coupling step of coupling
25 said toner developing container 12 having said
flexible sheet 42, said developing blade 10e and said
developing roller 10d with a or said cleaning

container 13 by engaging a or said pin 41 into them.

19. A method according to Paragraph 14 or 18, wherein said elastic member 66 is mounted on a side of said end seal 34.

5 20. A method according to any one of Paragraphs 14 to 19, wherein said seal is made of a plastically deformable material.

21. A method according to any one of Paragraphs 14 to 20, wherein in said developing blade 10e
10 mounting step, a new developing blade 10e or a used developing blade 10e is mounted.

22. A method according to any one of Paragraphs 14 to 21, wherein in said developing roller 10d step, a new or used developing roller 10d is mounted.

15 23. A method according to any one of Paragraphs 14 to 22, wherein prior to said container coupling process, said electrophotographic photosensitive drum 7 and said cleaning blade are dismounted from said cleaner container, and toner which has been removed
20 from said electrophotographic photosensitive drum 7 and accommodated in said cleaner container, is removed.

24. A method according to Paragraph 23, wherein after the toner is removed, a new or used
25 electrophotographic photosensitive drum 7 and a new or used cleaning blade are mounted.

25. A method according to any one of Paragraphs

14 to 24, wherein said remanufacturing method is implemented with a toner seal for sealing a toner supply opening 12a1 provided to supply the toner accommodated in said toner accommodating portion 10a to said developing roller 10d having been pulled out to supply toner accommodated in said toner accommodating portion 10a to said developing roller 10d.

26. A method according to any one of Paragraphs 1, 5, 14 and 18, wherein said process cartridge B comprises a gear fixed co-axially with said electrophotographic photosensitive drum 7 and a gear fixed co-axially with said developing roller 10d, which gears are in meshing engagement, and wherein after said container coupling process, said toner developing container 12 and said cleaner container are rotated about said pin 41 to disengage said gears from each other or to make a back clearance of the meshing engagement larger than that during image forming operation, and the disengagement or larger back clearance is maintained.

27. A method according to Paragraph 26, wherein said toner developing container 12 and said cleaner container are rotated toward each other about said pin 41 at a portion across said pin 41 from said electrophotographic photosensitive drum 7, and a tape is stuck on said toner developing container 12 and

said cleaner container to maintain the disengagement or the larger back clearance.

According to the present invention, an easy remanufacturing method for process cartridges, and an
5 easy remanufacturing method for process cartridges with which the tone leakage can be effectively prevented.

While the invention has been described with reference to the structures disclosed herein, it is
10 not confined to the details set forth and this application is intended to cover such modifications or changes as may come within the purpose of the improvements or the scope of the following claims.

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